

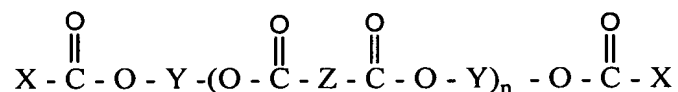
**Amendments to the Claims:**

The following claims will replace all prior versions of the claims in this application (in the unlikely event that no claims follow herein, the previously pending claims will remain):

1-18. (Cancelled).

19. (Currently amended) A composition comprising:

a metal working fluid comprising an ester ~~according to the formula~~  
represented by the following:



wherein

X is an aliphatic hydrocarbyl group having 5-11 carbon atoms;

Y is an alkylene group having 4-6 carbon atoms;

Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms  
and

n is a weight average number between 1.5 and 10.

20. (Cancelled).

21. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein  
the metal working fluid further comprising comprises an oil selected from a mineral  
oil, a vegetable oil, or an animal oil.

22. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein  
the metal working fluid further comprising comprises a surfactant.

23. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein  
the metal working fluid further comprising comprises an emulsifier.

24. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein the metal working fluid further comprising comprises a corrosion inhibitor.

25. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein the metal working fluid further comprising comprises water.

26. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein the metal working fluid further comprising comprises a metal deactivator.

27. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein the metal working fluid further comprising comprises an anti-foam agent.

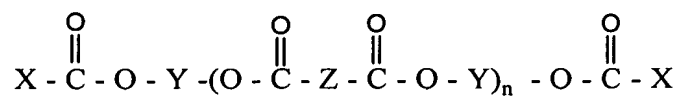
28. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein the metal working fluid further comprising comprises an anti-oxidant.

29. (Currently amended) The ~~metal working fluid composition~~ of claim 19 wherein the metal working fluid having has a kinematic viscosity at 100°C less than 20mm<sup>2</sup>/s and a kinematic viscosity at 40°C of less than 150mm<sup>2</sup>/s.

30. (New) The composition of claim 19, wherein n is a weight average number between 1.5 and 5.

31. (New) The composition of claim 19, wherein X is a saturated and linear aliphatic hydrocarbyl group having 7-9 carbon atoms, and wherein Y is a saturated and branched alkylene group having 4-6 carbon atoms.

32. (New) A composition comprising:  
a metal working fluid comprising an ester represented by the following:



wherein

X is an aliphatic hydrocarbyl group having 5-11 carbon atoms;  
Y is an alkylene group having 4-6 carbon atoms;  
Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms  
and  
n is a weight average number between 1.5 and 10; and  
wherein the ester has a kinematic viscosity less than 150 cst at 40°C.